

Date: Wednesday, 07/01/2009 1:39:07 PM
 User: Julie Dawson

Process Sheet

SPIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-ACCESS STEP RH (FOLDING)
Job Number	: 44489		
Estimate Number	: 12568		
P.O. Number	:	Part Number	: D412630034
This Issue	: 07/01/2009 S.O. No. :	Drawing Number	: IIN D412-630
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: L
Previous Run	: 44084	Material	:
Written By	:	Due Date	: 02/02/2009 Qty: 3 Um: 30 Each
Checked & Approved By	: <u>JD 09.01.09</u>		
Comment	: Est. Rev:A New Issue 06-11-08 JLM est rev B ecn1019, added D2807-041 EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Hj for JD 09/01/26



Comment: DOCUMENT CONTROL
 Photocopy bluefile & create labels per PPP D412-630-034 CHG003

2.0	D2012107	Clevis
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EP 09/02/18

Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

338773 (17) 345074 (3X)

3.0	D2803042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

B41673

EP 09/02/18

4.0	D2804042	Bracket Assembly
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EP 09/02/18

Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

B44551 (2X) B44492 (2X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2807041 Door prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Support Prop

Batch: B43901

EP09/02/18

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch
B41667

EP09/02/18

7.0 D3562042 Step Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-042	Step Weldment RH

Batch
44471

EP09/02/18

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch
B42180

EP09/02/18

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch
M101189

EP09/02/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 44489

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	AN8C16	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M105969

CP09/02/18

11.0	AN310C8	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M109148

CP09/02/18

12.0	MS24665302	Cotter Pin
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M106763

CP09/02/18

13.0	NAS1515H3	Washer
------	-----------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M109268

CP09/02/18

14.0	NAS1515H5L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M108964

CP09/02/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44489

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M109099

Ep 09/02/18

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M110023

(12)

M110153

(4)

Ep 09/02/18

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)
Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

Ep 09/02/18

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: M107929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M104251

Ep 09/02/18 (4)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/02/18 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44489

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

42174

JS 09/02/17 (X3)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

42175

JS 09/02/17 (X3)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

44552

9/1/10 SY

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

41670

JS 09/02/17 (X3)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M69147

JS 09/02/17 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44489

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M104679

SS 09/02/17 x3

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M107082

SS 09/02/17 x3

28.0 AN4C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C7A

Eyebolt

M100446

SS 09/02/17 x3

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M105125

SS 09/02/17 x3

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M69267

SS 09/02/17 x3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 44489

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch

7 NAS1515H5 Washer

M109430

SS 09/02/17 (x3)

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21043-4 Nut

M110023

SS 09/02/17 (x3)

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description Batch

3 MS21043-5 Nut

M110123x7

M109535x2

SS 09/02/17 (x3)

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09-02-20 (3)

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

09/02/20 (3)

36.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/23

Job Completion



09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

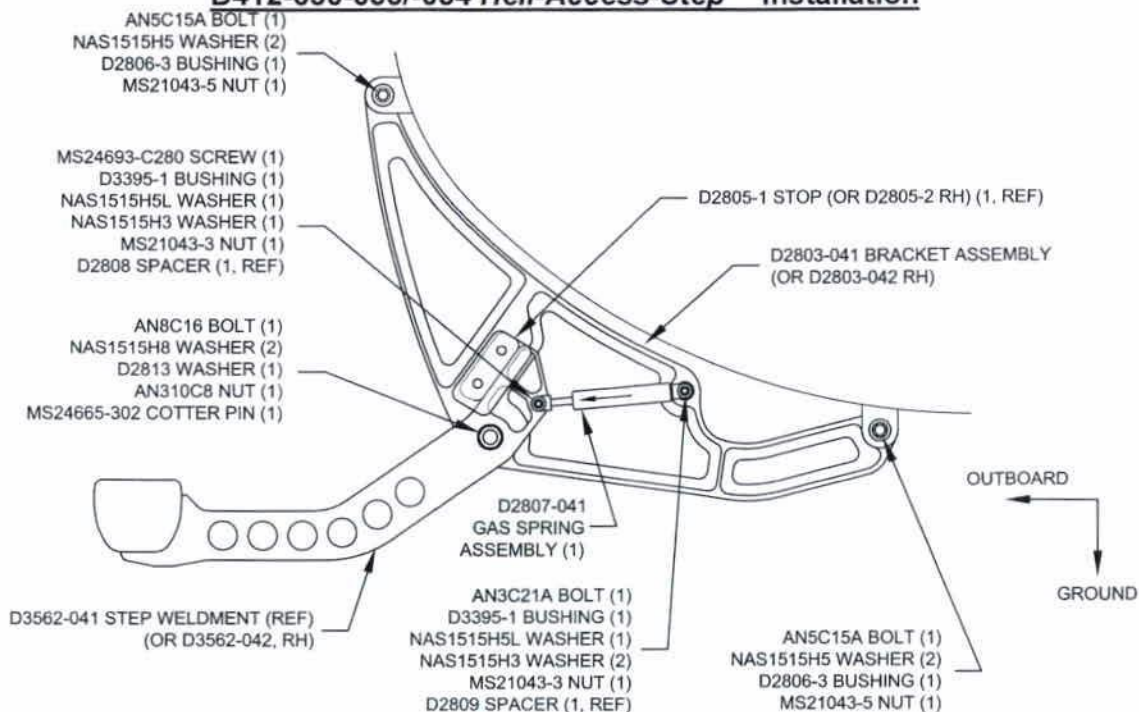
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

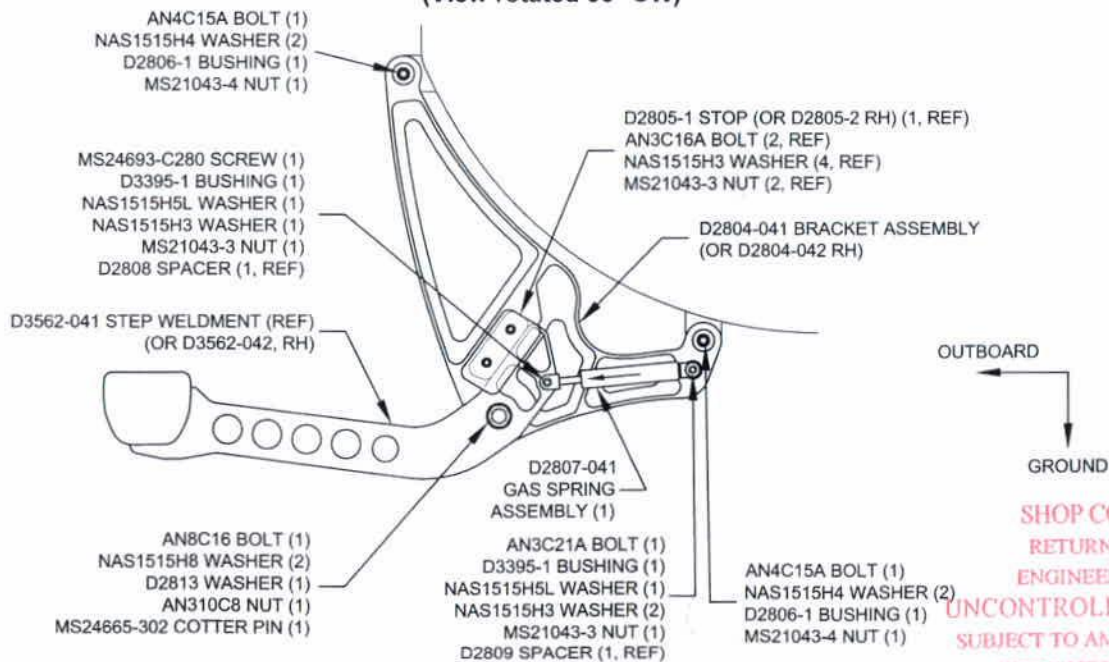


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 144/89

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Revision: L
Date: 07.09.30

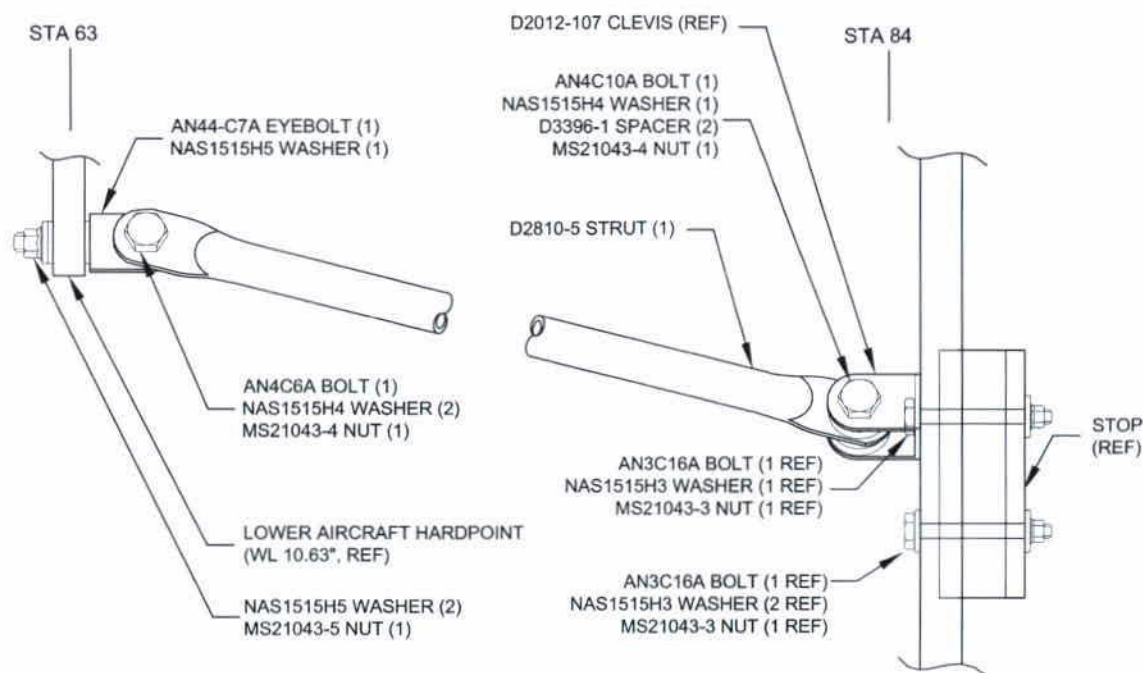


FIGURE 16 – Strut Detail for D412-630-033/-034 *Heli-Access-Step™* Installation
(NOT TO SCALE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44489